

Split

Work Order ID 75055

October-17-11 10:40:08 AM

75055

Page 1

Item ID: D3296-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Door Assembly

Stop

NS2

Start Date: 17/10/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 28/10/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: 11/10/11 Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3296	Rev A

100 *100* Small Fab 0.00

Small Fab Memo 0.00

Small Fab Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

110 *110* QC5- Inspect part completeness to step on W/O 0.00

QC Memo 0.00

Quality Control

120 *120* Powdercoat Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00

Powder Coating Memo 0.00

START TIME: *9:15* OVEN TEMPERATURE:
FINISH TIME: *9:45*

320°F

E/S 11/11/28 (10)

M 11. 11. 28 (10)

10X Ø M 11/11/30

M 11/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00

D 11-11-30

130

QC

Quality Control

Memo

0.00

140

140

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Assemble as per Dwg D3296

L 12/01/10

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11 12 01 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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10

Cust Item ID:

Required Date: 28/10/2011 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

160

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

ST218

170

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/11/11 10

11/12/11

MF
11-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 75055

75055

Parent Item: D3296-041

D3296-041

Parent Item Name: Door Assembly

Start Date: 17/10/2011

Required Date: 28/10/2011

Comments: IPP C05,10.14 Added step 14KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-7 *D3161-7* Hinge 14.0"		Manufactured	No			100	Each	14.0000	1	10	<i>Epu 11/11/18</i>	<i>B76938</i>	
							<u>Location</u>	<u>Loc Qty</u>					
							ST037	14					
							72725	6					
							74609	8					
D3161-9 *D3161-9* Hinge 17.0"		Manufactured	No			100	Each	14.0000	1	10	<i>Epu 11/11/18</i>	<i>B76939</i>	
							<u>Location</u>	<u>Loc Qty</u>					
							ST037	14					
							72726	8					
							74610	6					
D3296-1 *D3296-1* Door Panel		Manufactured	No			100	Each	20.0000	1	10	<i>Epu 11/11/23</i>		
							<u>Location</u>	<u>Loc Qty</u>					
							ST186	20					
							71719	4					
							74614	16					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 75055

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D3296-041

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 10.00

Required Qty: 10.00

D3296-3

Manufactured No

100

Each

24.0000

**

1

10

D3296-3

Door Panel

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST186	16	
74615	16	
ST196	8	
71717	8	

MS20470AD4-6

Purchased No

100

Each

2,509,000

**

1

10

MS20470AD4-6

Rivet, Universal Head

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST319	1509	
117395	68	
117887	8	
118927	1433	
ST320	1000	
119109	1000	

D2137

Manufactured No

140

Each

24.0000

**

1

10

D2137

Decal - No Step

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	10	
74029	10	
ST006	14	
72053	14	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D3296-041

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 10.00

Required Qty: 10.00

D2419

Manufactured No

140 Each

16.0000

**

10
GP11/12/01
4
6

D2419

Handle

Location	Loc Qty	Loc Code
GA	16	
69732	4	
74514	12	

D2462

Manufactured No

140 f

455.8674

0.3333

3.333

GP11/12/01
3.333

D2462

Seal

Location	Loc Qty	Loc Code
ST404	455.8674	
48530	455.8674	

D2728-1

Manufactured No

140 Each

0.0000

0

0

GP11/12/01
3.333

D2728-1

Dart Logo label

MS20470AD4-4

MS20470AD4-4

Rivet, Universal Head

Purchased No

140 Each

4,190.000

25

250

GP11/11/13
250

Location	Loc Qty	Loc Code
ST139	78	
117423	78	
ST319	4112	
116188	136	
116391	66	
118614	1910	
119109	2000	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D3296-041

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 10.00

Required Qty: 10.00

NAS1149DN632J

Purchased

No

140

Each

795.0000

1

10

**

NAS1149DN632J

Washer

Location	Loc Qty	Loc Code
ST297	795	
118428	795	

GP 11/10/11
10

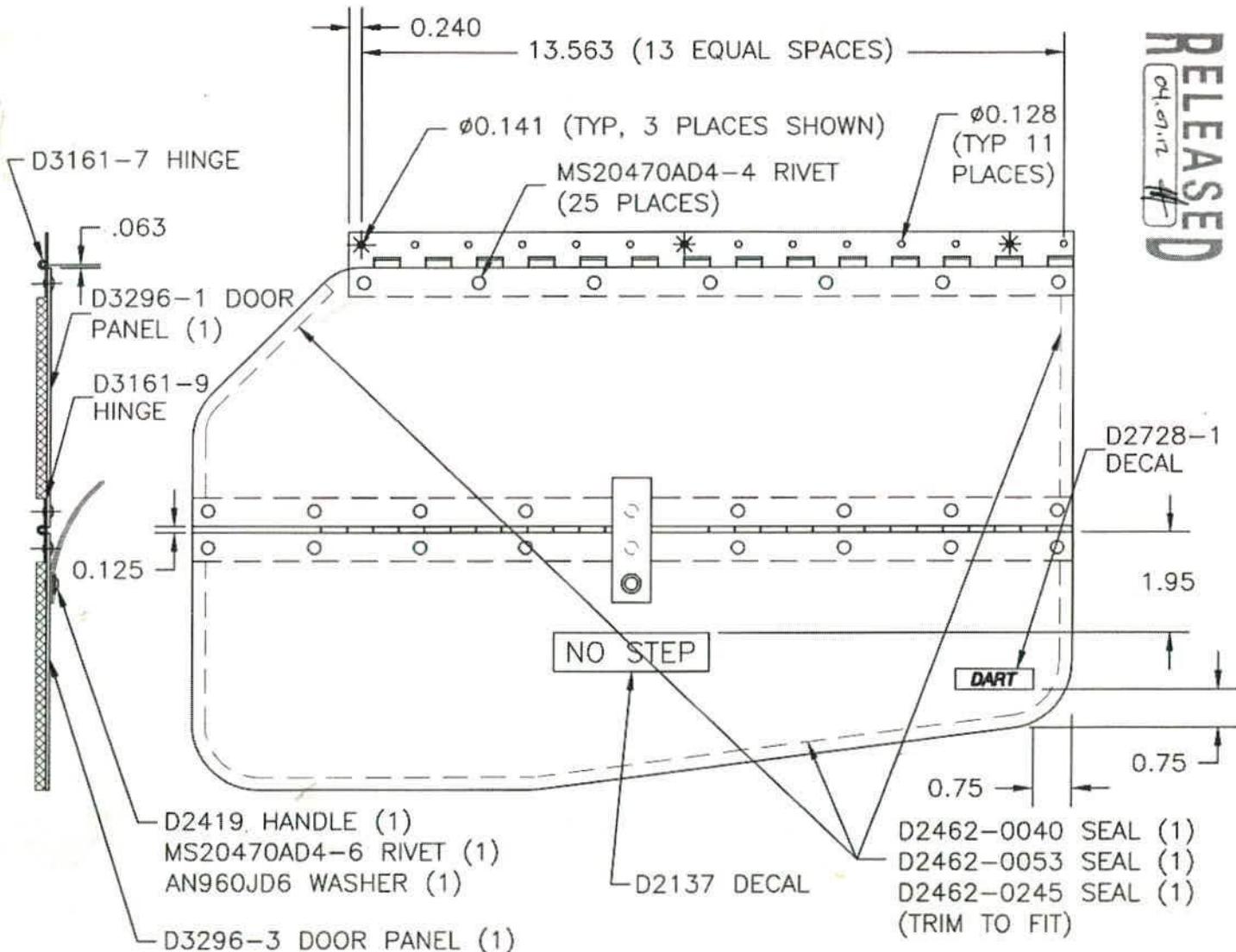
W/O:		WORK ORDER CHANGES							
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D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

SHOP COPY
RETURN
ENGINEER
UNCONTROLLED
SUBJECT TO CHANGE
WITHOUT NOTICE
NO. 75054
75054
R11.10.11

DART

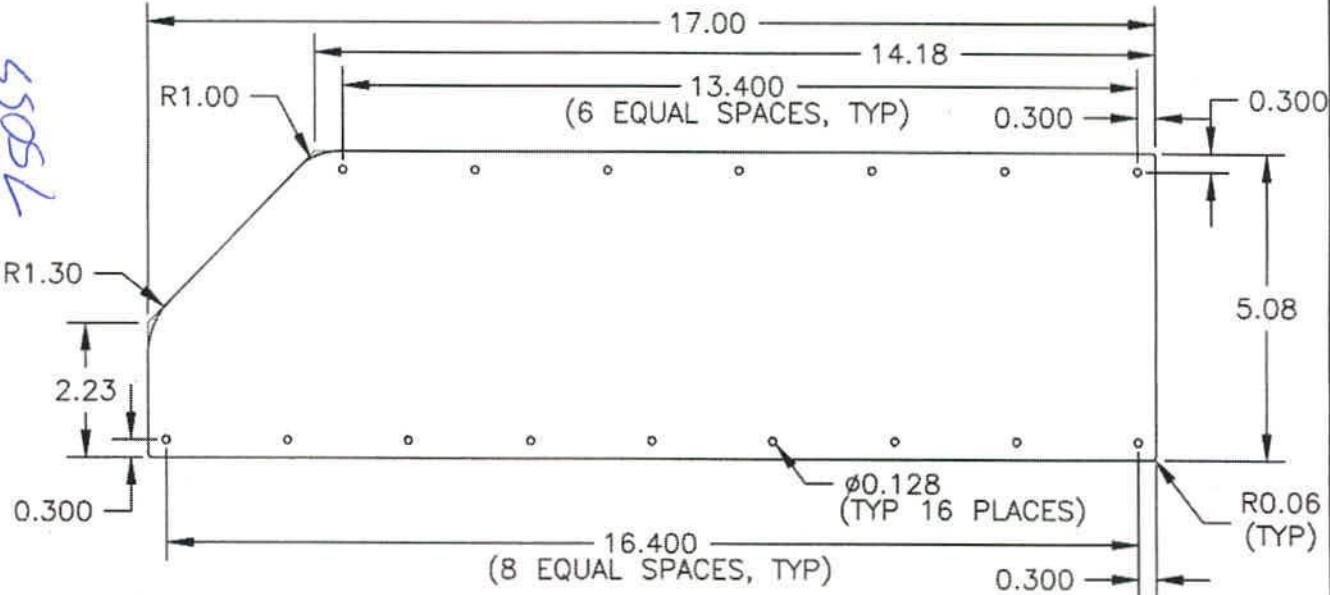
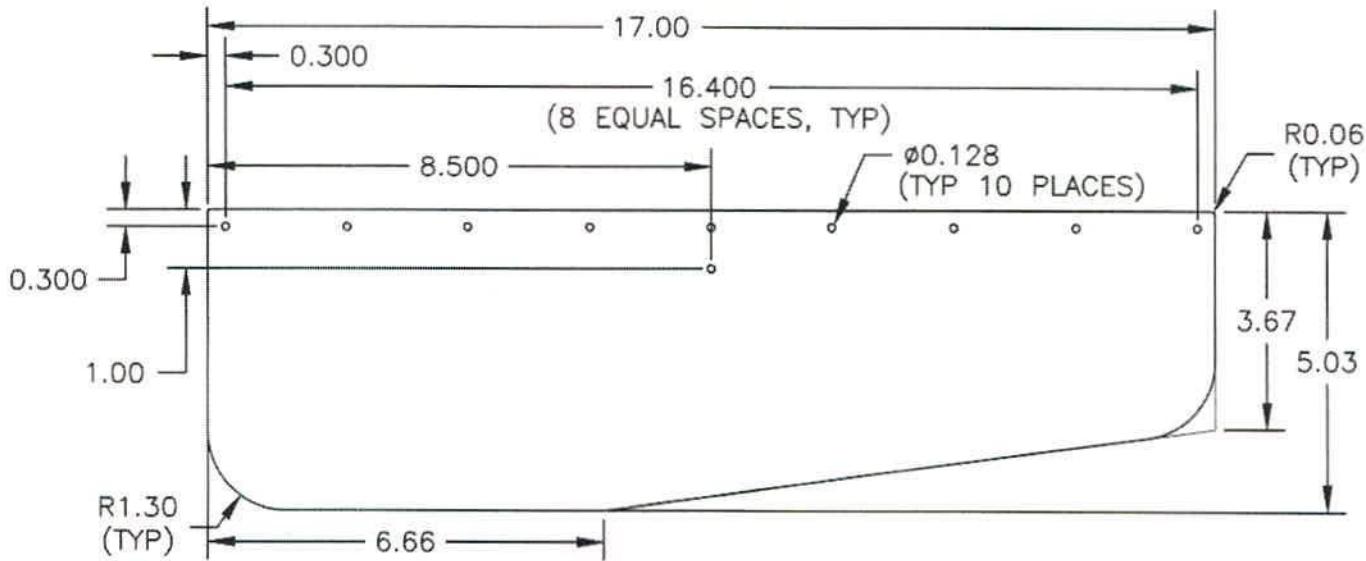
OACOPY
IS
USED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE		DRAWING NO. D3296
04.06.28		TITLE DOOR ASSEMBLY
A	04.06.28	REV. A 1 OF 2 SCALE 1:3 NEW ISSUE

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3296	2 OF 2
DATE		TITLE	SCALE
04.06.28		DOOR ASSEMBLY	1:3

15055

D3296-1 DOOR PANELD3296-3 DOOR PANELD3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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